ABSTRACT

An ultrasonic welding structure for pressing a horn (3) against a columnar heating target consisting of a resin (10), applying a high frequency vibration from the hone (3) to the heating target, and thereby fusion-bonding the heating target to a predetermined bonding target, wherein the bonding target includes an insertion hole for inserting the heating target, and the insertion hole of the bonding target includes a notch formed in an inner edge of the insertion hole on a side facing the resonator. The notch of the insertion hole can be formed to serve as an acceptance unit that accepts the heating target in a molten state. Alternatively, the notch of the insertion hole can be formed to serve as a stress relaxing unit that relaxes a stress generated within the bonding target by contacting with the inner edge of the insertion hole.